

Appendix B

Bead-on-plate wet welds

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B.1 Initial bead-on-plate welds



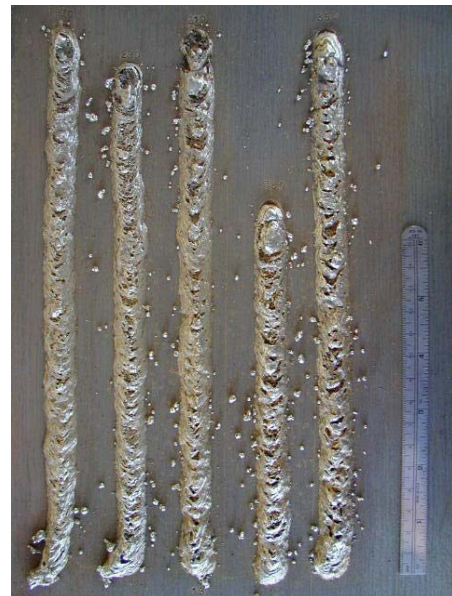
(a) E6013 at 50 m



(b) E7018 at 50 m



(c) E7024 at 50 m



(d) E6013 at 100 m



(e) E7048 at 100 m



(f) E7024 at 100 m

Figure B.1. Pictures of the initial bead-on-plate wet welds deposited with the three electrodes using different current values and electrode positive at 50 and 100 m.

A.2 Bead-on-plate wet welds

A.2.1 BOP welds on A36 Steel



(a) E6013 and 260 A



(b) E7018 and 280 A



(c) E7024 and 310 A

Figure B.2. Pictures of the bead-on-plate wet welds deposited with the three electrode types using electrode positive on A36 steel plates at 50 m.



(d) E6013 and 280 A



(e) E7018 and 280 A



(f) E7024 and 310 A

Figure B.3. Pictures of the bead-on-plate wet welds deposited with the three electrode types using electrode positive on A36 steel plates at 100 m.



(g) E6013 and 260 A



(h) E7018 and 280 A



(i) E7024 and 310 A

Figure B.4. Pictures of the bead-on-plate wet welds deposited with the three electrode types using electrode negative on A36 steel plates at 50 m.



(j) E6013 and 280 A



(k) E7018 and 280 A



(l) E7024 and 310 A

Figure B.5. Pictures of the bead-on-plate wet welds deposited with the three electrode types using electrode negative on A36 steel plates at 100 m.

A.2.2 BOP welds on A572 Gr. 50 Steel



(m)E6013 and 260 A



(b) E7018 and 280 A



(c) E7024 and 310 A

Figure B.6. Pictures of the bead-on-plate wet welds deposited with the three electrode types with electrode positive on A572 Gr. 50 steel plates at 50 m.



(a) E6013 and 280 A



(b) E7018 and 280 A



(c) E7024 and 310 A

Figure B.7. Pictures of the bead-on-plate wet welds deposited with the three electrode types with electrode positive on A572 Gr. 50 steel plates at 100 m.



(a) E6013 and 260 A



(b) E7018 and 280 A



(c) E7024 and 310 A

Figure B.8. Pictures of the bead-on-plate wet welds deposited with the three electrode types with electrode negative on A572 Gr. 50 steel plates at 50 m.



(a) E6013 and 280 A



(b) E7018 and 280 A



(c) E7024 and 310 A

Figure B.9. Pictures of the bead-on-plate wet welds deposited with the three electrode types with electrode negative on A572 Gr. 50 steel plates at 100 m.

A.2.3 BOP welds on API 5L Gr. B



(a) E6013 and 260 A



(b) E7018 and 280 A



(c) E7024 and 310 A

Figure B.10. Pictures of the bead-on-plate wet welds deposited with the three electrode types with electrode positive on API 5L Gr. B steel plates at 50 m.



(a) E6013 and 280 A



(b) E7018 and 280 A



(c) E7024 and 310 A

Figure B.11. Pictures of the bead-on-plate wet welds deposited with the three electrode types with electrode positive on API 5L Gr. B steel plates at 100 m.



(a) E6013 and 260 A



(b) E7018 and 280 A



(c) E7024 and 310 A

Figure B.12. Pictures of the bead-on-plate wet welds deposited with the three electrode types with electrode negative on API 5L Gr. B steel plates at 50 m.



(a) E6013 and 280 A



(b) E7018 and 280 A



(c) E7024 and 310 A

Figure B.13. Pictures of the bead-on-plate wet welds deposited with the three electrode types with electrode negative on API 5L Gr. B steel plates at 100m.